

50.8

NO MAY ??

Dart Aerospace Ltd.

Date: Wednesday, 18/06/2008 1:26:36 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE BLOCK
 Job Number : 39919
 Estimate Number : 10324
 P.O. Number :
 This Issue : 18/06/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : MACHINED PARTS
 Previous Run : 38274
 Written By :
 Checked & Approved By : JUL 08.6.18
 Comment : Est RevC 02.04.10 Re-format NG

Part Number : D1049
 Drawing Number : D1049 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 11/07/2008 Qty: ~~80~~ 50 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X00250 6061-T6 Bar .750 x .250



Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)
 Material: 6061-T6 bar .750 wide x .250 thick.
 Batch M107904

2.0 SHEAR SHEAR



Comment: SHEAR
 Cut Blanks: 2.000" long

SD 08/07/04

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine'as per folio FA217 & Dwg D1049

2-Deburr

SD 08/07/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 08/07/04

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/07/04

POSITIVE RECALL

EFFECTIVE 08/07/04 AUTH LS

RELEASED u DATE 08/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:26:36 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 39919

Part Number: D1049

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(54)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-07-08

7.0

POWDER COATING

POWDER COATING



m102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

(54)

START TIME:

11:30

OVEN TEMPERATURE:

320

FINISH TIME:

12:00

12/07 08107109

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18 08/07/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 2

18 08107110 (54)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

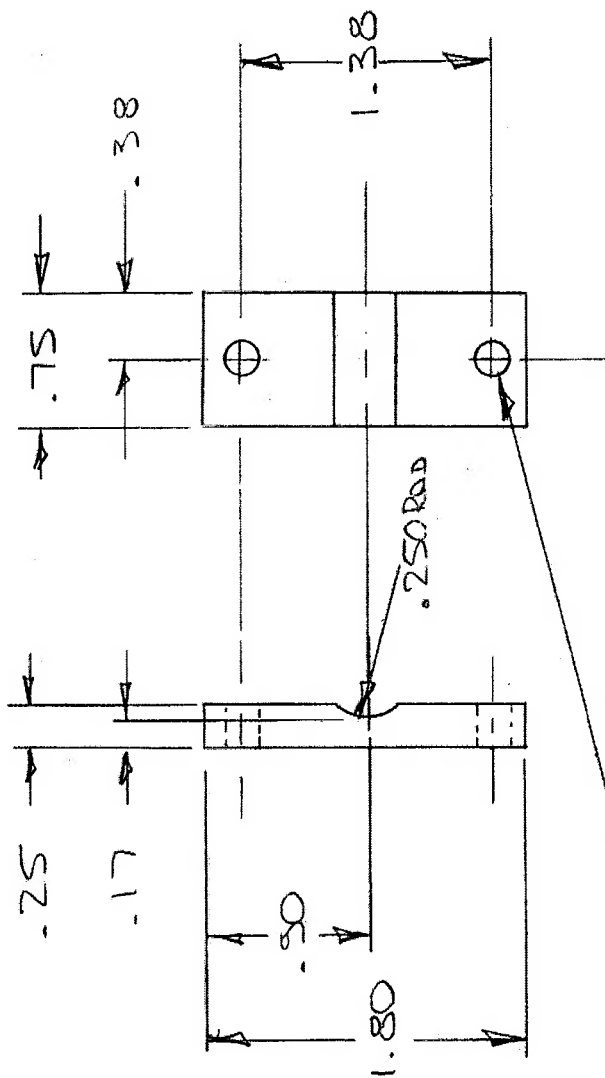
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
R 97/08/02 B.W.



MATERIAL: S052-H32

FINISH: POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38919



REVISION		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC/VENDOR	
DRAWN		CONTRACT NO.						DART		DART AERO ACCESSORIES INC. CANADA	
APPROVED		DRAWN		DATE							
DESCRIPTION OF CHANGE		DESIGN		1/11/77							
		STRESS								SADDLE	
		CHECKED								D1049	
		EIGHT								REV	
										SCALE	
										SHEET	
										OF 1	

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REQUIREMENTS - UNLESS OTHERWISE SPECIFIED

GENERAL	LIMITS
1. DIMENSIONS ARE IN INCHES	1. TOLERANCES - SEE 4.000
2. SURFACE FINISHES ARE	2. ANGLES - SEE 4.010
3. REMOVE SHARP EDGES .015 MAX	3. FINISHES - SEE 4.020
4. REMOVE PERMANENT STAINS	4. ECCENTRICITY - SEE 4.030
5. REMOVE PERMANENT STAINS	5. STRAIGHTEN BY ABOUT 1.000 MAX
	ALL DIMENSIONS ARE .005

REPORT ALL DISCREPANCIES - DO NOT SCALE